



007413

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB DB3188L
Job Sheet 184746



Part No: RB DB3188L

Job Qty: 5 ea

Part Name: Drain Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB DB3188L Rev 6 IPP Rev A 18.02.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	5 pcs	12/14/18	12/14/18	0.00	0.63	Small Fab-9		MLLAS
110	QC	5 pcs	12/14/18	12/14/18	0.00	0.00	QC5		38
130	Packaging	5 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2		Dan
140	QC21-FG	5 Ea	12/14/18	12/14/18	0.00	0.00	QC21		21 JAN 1 10 2019

Part Op 100 - Assemble as per DWG
Descriptions: 130 - Identify and Stock

GA 152A

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
51495K116	COUPLING 1/2" NCKL PLTD BRASS	7.5 Ea (1 ea)	90-Start up Operation	5137369
9263K642	O-Ring	7.5 Ea (1 ea)	90-Start up Operation	5078377
9464K27	O-Ring As568A Dash Number 114	7.5 (1 ea)	90-Start up Operation	5120486
FT-33	Container	7.5 pcs (1 ea)	90-Start up Operation	5017273
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	42 30 ft (6 ea)	90-Start up Operation	5134727-36 5098411-71
PAD210	Foam Ø1 X 1	.2350 sf (.047 ea)	90-Start up Operation	5024250
RB DB3188L-1	Drain Hose Adapter	7.5 Ea (1 ea)	90-Start up Operation	5137455
RB DB3188L-3	Swivel	7.5 Ea (1 ea)	90-Start up Operation	5137117
RB DB3188L-5	Drain Hose Adapter	7.5 Ea (1 ea)	90-Start up Operation	5137463
WA 84	TBD	7.5 (1 ea)	90-Start up Operation	5139963
90145A443	Dowel Pin	21 15 Ea (3 ea)	90-Start up Operation	5139527
90145A433				5042368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	51495K116	5	40	0
	90145A443	15	100	0
	9263K642	5	60	0
	9464K27	5	0	0
	FT-33	5	99	0
	K010-0608	30	321	0
	PAD210	0	12	0
	RB DB3188L-1	5	0	0
	RB DB3188L-3	5	0	0
	RB DB3188L-5	5	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Part Specifications

Specifications could not be found.

Plex 10/16/18 1:52 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S143612

Part: FB DB3188L

Job No: 184746

Serial No/Batch: S143612

Revision: 6A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/10/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

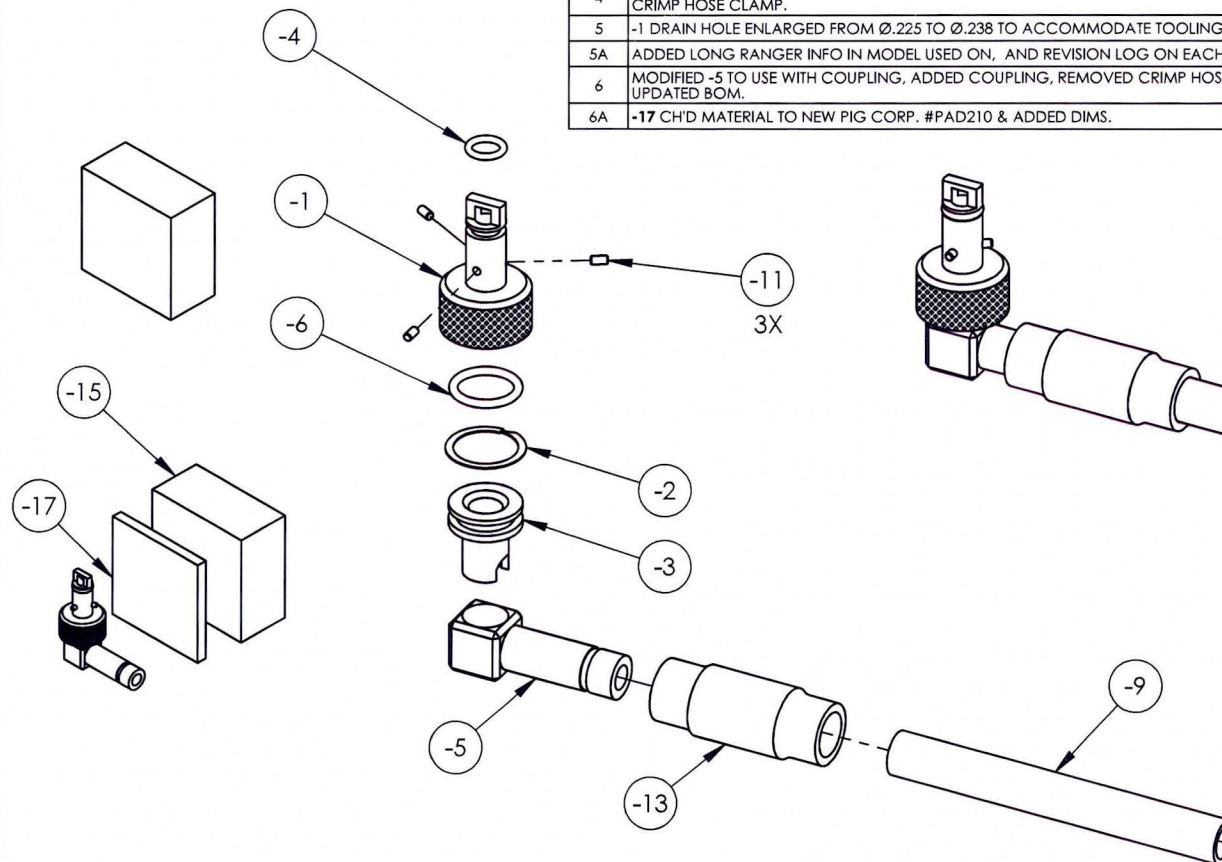
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	O.D. ON STEPS OF -5 INCREASED FROM Ø.400 TO Ø.425 TO BETTER GRIP TUBING.	8/13/2004	-	-
2	REMOVED FROM -3 .285 DIM. (x .255) RE-ORGANIZED & RESIZED DIMS.	6/12/2007	WP	GE
3	REDUCED AND RE-ORGANIZED DIMS, MOVED PARTS TO ELIMATE ONE PAGE, MOVED ALL BOM'S TO FIRST PAGE, CHANGED -9 HOSE LENGTH FROM 24 in. TO 6 ft., AND ADDED CUT-2 SPIRAL LOCK RING IN HALF.	6/28/2007	WP	DW
4	DELETED -7 7 TWO HOSE RIBS FROM -5. ADDED INFO FOR CLARITY & INSTALLED NEW DRAWING FORMAT. ADDED -13 CRIMP HOSE CLAMP.	5/16/2008	WP	RW
5	-1 DRAIN HOLE ENLARGED FROM Ø.225 TO Ø.238 TO ACCOMMODATE TOOLING.	3/17/2009	WP	GE
5A	ADDED LONG RANGER INFO IN MODEL USED ON, AND REVISION LOG ON EACH PAGE.	12/3/2009	WP	DW
6	MODIFIED -5 TO USE WITH COUPLING, ADDED COUPLING, REMOVED CRIMP HOSE CLAMP, ADDED -15, -17, EXP VIEWS, UPDATED BOM.	7/26/2012	JAG	
6A	-17 CH'D MATERIAL TO NEW PIG CORP. #PAD210 & ADDED DIMS.	1/31/2014	JAG	RW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184746 MJS
18-10-16

1. CUT -2 SPIRAL LOCK RING IN HALF TO FIT. ONE LOCK RING MAKES TWO UNITS.
2. WHEN PRESSING -3 SWIVEL INTO -5 HOSE END ALIGN CUTOUT IN -3 WITH STEM HOLE.
3. USED ON MODELS BELL 206L, LONG RANGER, MAIN TRANSMISSION L1, 2, 3, & 4.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	Ø1 X 1-3/4	2
		B/O	-2	1	SPIRAL LOCK RING	STEEL	APPLIED SMALLEY #WA 84	1
			-3	1	SWIVEL	6061	Ø7/8 X 1	3
		B/O	-4	1	O-RING	VITON	2-011N70 OR MCMASTER-CARR #9263K642	1
			-5	1	HOSE END	6061	5/8 X 5/8 X 2-1/8	4
		B/O	-6	1	O-RING	VITON	2-114 OR MCMASTER-CARR #9464K27	1
			-9	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-11	3	DOWEL PIN	S.S.	Ø3/32 X 3/16 MCMASTER-CARR #90145A448	1
		B/O	-13	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMASTER-CARR #51495K116	1
		B/O	-15	1	BOX	CLEAR POLYPROPYLENE	DE LUZ FLEX-A-TOP FT-33	1
		B/O	-17	1	FOAM	POLYESTER/POLYURETHANE	1 X 2.6 X 2.6 NEW PIG CORP. #PAD210	1

RED BARN MACHINE	
TITLE TRANSMISSION DRAIN TOOL	
DWG NO. RB DB3188L	REV 6A
DRAWN BY: D ROBERTS	
APPROVED: D Wed	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 4/15/2002
SHEET 1 OF 4	

Linda Lacelle

From: Chantal Lavoie
Sent: Thursday, December 20, 2018 3:05 PM
To: Michael Lee; Linda Lacelle; Daniel Paquette
Cc: Jean-Luc Menard
Subject: RE: Contact Form [#13563]

RB DB3182

Thank you Mike,
Will order the parts from McMaster.
Chantal

From: Michael Lee <mlee1@dartaero.com>
Sent: Thursday, December 20, 2018 3:03 PM
To: Linda Lacelle <llacelle@dartaero.com>; Daniel Paquette <dpaquette@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>
Subject: RE: Contact Form [#13563]

Hey,

It appears that the Smalley P/N should read **WH-84**.

The Smalley dims are attached.

The closest McMaster alternative is **92602A140** or **93427A140**.

We will add this drawing to the list of drawings to fix.....

Leave the W/O on my desk and I will add the deviation over the holidays.

Cheers,

Mike

From: Linda Lacelle <llacelle@dartaero.com>
Sent: Thursday, December 20, 2018 2:48 PM
To: Daniel Paquette <dpaquette@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>; Michael Lee <mlee1@dartaero.com>
Cc: Jean-Luc Menard <jmenard@dartaero.com>
Subject: RE: Contact Form [#13563]

He's here today, and we need a response or this doesn't ship

From: Daniel Paquette <dpaquette@dartaero.com>
Sent: Thursday, December 20, 2018 2:44 PM
To: Linda Lacelle <llacelle@dartaero.com>; Chantal Lavoie <clavoie@dartaero.com>
Subject: RE: Contact Form [#13563]

FYI.

Mike is supposed to be on vacation to the best of my knowledge and Ketan is not in until the 24th.

From: Linda Lacelle <llacelle@dartaero.com>
Sent: Thursday, December 20, 2018 2:41 PM
To: Chantal Lavoie <clavoie@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Ketan Tailor <ktailor@dartaero.com>
Cc: Daniel Paquette <dpaquette@dartaero.com>
Subject: RE: Contact Form [#13563]
Importance: High

And we need this here like tomorrow!!

From: Chantal Lavoie <clavoie@dartaero.com>
Sent: Thursday, December 20, 2018 2:32 PM
To: Michael Lee <mlee1@dartaero.com>; Ketan Tailor <ktailor@dartaero.com>
Cc: Daniel Paquette <dpaquette@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Subject: FW: Contact Form [#13563]

Hi Mike,
I need more info on item WA 84 from dwg RB DB188L. Please advise if there a alt. p/n from McMaster or need more info on dimension for Applied Smalley.
Thanks
Chantal

From: 4318 LAVAL, QC <4318@applied.com>
Sent: Thursday, December 20, 2018 2:24 PM
To: Chantal Lavoie <clavoie@dartaero.com>
Subject: TR: Contact Form [#13563]

Bonjour avez vous plus d information sur le produit que vous recherchez (fabricant modèle est-ce métrique ou impérial)

Hello do you have more information .

Best regards

De : customerservice
Envoyé : Thursday, December 20, 2018 11:21 AM
À : 4318 LAVAL, QC
Objet : FW: Contact Form [#13563]

The request below was received via Applied.com customer service. Please review and respond directly to the customer as appropriate.

Regards,

Applied.com Support

From: Wufoo [<mailto:no-reply@wufoo.com>]
Sent: Thursday, December 20, 2018 10:52 AM
To: customerservice
Subject: Contact Form [#13563]

Question/Comment

Good morning,
please advise price an delivery on item.

SPIRAL LOCK RING NO. WA 84 X 20 pcs

Name

Chantal Lavoie

Email Address *

clavoie@dartaero.com

Company

Dart Aerospace

Address *



1270 Aberdeen
Hawkesbury, Ontario K6A 1K7
Canada

Phone Number

(613) 632-5200

■
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